Work Ord Wednesday, Jul	ler ID 6	<b>0720</b> 10:20:10 AM						-		1		D
Item ID: Revision ID: Item Name:	D3907-1 Bushing			Accept	1881/18/8/8/8/8/8/8/8/8/8/8/8/8/8/8/8/8				Setup	Start		Page
Start Date: Required Date: Reference:	7/21/2010 7/28/2010	Start Qty: 40. Req'd Qty: 40.		8/8/1 88/1 (88) 8/8/1 88/1 (88)	Cust Item Customer					Stop		
Approvals:  Sequence ID/	Process Pl	an:	Date: <u>/</u>	Tooling:  SPC (Y/N):		Date:		ī	Run	Start Stop		
Work Center II  Draw Nbr		Operation Description Vision Nbr		Set Up/ Run Hour	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	insp. Stamp
D3907  100  Hardinge  Hardinge CNC Lathe	A Small	<b>Memo</b> Machine & Dwg D Dwg Rev folio Rev Deburr	: <b>\</b> _	0.00				4 (	<b>\$</b>	<u>(</u>		
110 QC Quality Control		QC2- Inspect parts off  Memo	machine FAI/FAIB .	0.00			•	41	Ø	<u></u>		

SN 10/07/22

W/O:												
DATE	STEP	PROCEDURE CHANGE By Da						Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									1 Tod Wgi			
										}		
	:											
<del>-</del>												
Part No			: Fault Category:			Yes I	No <b>DQ</b>	QA Date:				
				Disposition:			sed:		Date:			
NCR:		,	WORK OR	DER NON-CONFORM	ANCE	NCR	)					
DATE	STEP	Description of NC			ection B Verific				Approval	Approval		
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	dn C	Chief Eng	QC Inspector		
				- 1 W								
									<u> </u> 			
					i							

Work	Order	ID	60720
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Wednesday, July 21, 2010 10:20:10 AM



Page 2

Item ID:

D3907-1

**Revision ID:** Item Name:

**Start Date:** 

7/21/2010

Bushing

Required Date: 7/28/2010

**Start Qty: 40.00** Req'd Qty: 40.00





Setup Start



Stop

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Tooling:

QC: \_\_\_\_\_ Date: \_\_\_\_ SPC (Y/N):

Accept

Date:

\_ Date: \_

Run Start

Stop



Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 

10/07/4122

Tool ID Tool # Plan

Cust Item ID:

Customer:

Accept Qty

Code

Reject Qty

Reject Insp. Number

Stamp

130

Packaging

Identify as per dwg & Stock Location: WA

Memo

0.00

SAD 10-07-26

140

Packaging

QC21- Final Inspection - Work Order Release

0.00

0.00

Quality Control

Memo

0.00

10/0+7/26 A

N/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	<b>Q</b> ty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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					,								
Part No	:	PAR #:	PAR #: Fault Category: NCR: Yes No DQ						A Date:				
	Re	solution:	Disposition:				sed:	_	Date: _				
NCR:		,	WORK ORI	DER NON-CONFORM	ANCE	(NCR	)						
DATE	STEP	Description of NC	Initial		ction B	Sign &	Verific		Approval	Approval			
		Section A	Chief Eng	Action Description Chief Eng		Date	Section	n C	Chief Eng	QC Inspector			
			i I										
		a Constitution of the Cons											

#### **Picklist Print**

Wednesday, July 21, 2010 10:20:14 AM

Work Order ID: 60720

Parent Item:

D3907-1

Parent Item Name: Bushing



**Start Date:** 7/21/2010

Required Date: 7/28/2010

Page 1

**Start Qty: 40.00** 

Required Qty: 40.00

#### **Comments:**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375	1146 (****** <b>****</b> ** <b>*</b> *** (****	Purchased	No			100	f	19.1400	0.03	1.2			

304 ROUND BAR 0.375

Location	Loc Qty	Loc Code
MAT	13.8	
111323	0	,1'
114467	5.1	, ,
114676	1.1	
115180	7.6	
MAT029	5.34	
113325	3.85	
114356	1.49	

1,3ft SA10104122

N/O:									
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
-								- Tourist	
			•						
				· · · · · · · · · · · · · · · · · · ·					
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Ye	s No Do	) <b>-</b>	Date:	
	Resolution:		Disposit	ion:	_ QA: N/C	Closed: _		Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NC	CR)			
DATE	STEP	Description of NC	1	Corrective Action Section			ication	Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sigi Da		ction C	Chief Eng	QC Inspector
				·					
		·							

DART AEROSPACE LTD	Work Order:	60720
Description: Bushing	Part Number:	D3907-1
Inspection Dwg: D3907 Rev: A		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	.312	1,			•
0.25	+/-0.030	1258	//			
0.059	+/-0.010	1059	//			
Ø0.257	+0.006/-0.001	0,257				
••				-		
			<u> </u>			
				,	<u> </u>	<del>-</del>

Measured by:	Audited by:	mg/	Preliminary Approval:	
Date: 1007 22	Date:	10/07/22	Date:	

Rev	Date	Change	Revised by	Approved
Α	09.05.20	New Issue	KJ	
В	10.06.07	Tolerance for dimension Ø0.375 revised	KJ 🙀	

#### **Dart Aerospace Ltd WORK ORDER CHANGES** W/O: **Approval Approval** DATE **STEP** PROCEDURE CHANGE Qty By Chief Eng / Prod Mgr Date QC Inspector Part No: PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_ \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_ Resolution: WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Verification **Description of NC Approval Approval** STEP DATE Sign & Initial **Action Description** Section A Section C Chief Eng QC Inspector Chief Eng Date Chief Eng

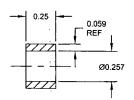
**ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT

SHOP COPY **RETURN TO** 

WITHOUT NOTICE

WORK ORDER NO. 40220 BS10-221

Ø0.375



D3907-1 BUSHING

SECTION A-A<sub>C5-1</sub>

В

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD REF DART SPEC M304R

> OR: AISI 304/316 STAINLESS STEEL BAR REF DART SPEC M304B

2) FINISH: NONE 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

09.03.11 DATE Α NEW ISSUE AJS REV. DESCRIPTION BY DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A SHEET 1 OF 1 MFG. APPR. D3907 APPROVED TITLE SCALE DE APPR. BUSHING (BASKET REPAIR) THE OF THE OF THE PROPERTY OF DATE 09.03.11

W/O:										
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			to the state of th				•			
Part No	•	PAR #:		tegory:	NCI	R: Yes	No <b>DQ</b>	4	_ Date: _	
	Resolution:			ion:	QA	N/C CIG	osed:	ļ	Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE	(NCR	)		-	
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
	,							}		
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